

Work Order ID 58360

Tuesday, May 04, 2010 11:21:55 AM



Page 1

Item ID: D3916-5

Accept



Revision ID:

Setup Start



Item Name: Light Rib

Stop



Start Date: 5/4/2010 Start Qty: 12.00

Required Date: 5/7/2010 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 10-5-4

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3916

A

100



Large Fab

Large Fab

0.00

Memo

0.00

- 1- Cut tube 50" → *SAD 10-05-04 - (12)*
- 2- Bend tube with manual pipe bender as per DT9566
- *** Make line at 9.00" and use jig for other line***
- 3- Trim access tube material to finish size as per dwg D3916

(12) PD 10.05.05

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S wloslos

(12)

120



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Basket cell

Memo

0.00

Set 10/05/06 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Revision ID:

Item Name: Light Rib

Start Date: 5/4/2010

Start Qty: 12.00

Required Date: 5/7/2010

Req'd Qty: 12.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/05/07 *[Signature]*
MF
10-5-6

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Picklist Print

Tuesday, May 04, 2010 11:21:55 AM

Page 1

Work Order ID: 58360

Parent Item: D3916-5

Parent Item Name: Light Rib

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
as per dwg revA 10.03.15 verified by:EC

IPP Rev:B

Start Date: 5/4/2010

Required Date: 5/7/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304TS0.500W.049		Purchased				100	f	173.2199	4.166			
Square Tubing												

Location

Loc Qty

Loc Code

MAT		153.6893
	114426	153.6893
MAT018		19.5306
	114004	3.5
	114161	16.0306

SAO 10-05-07

4.166 x 12 (49.992)

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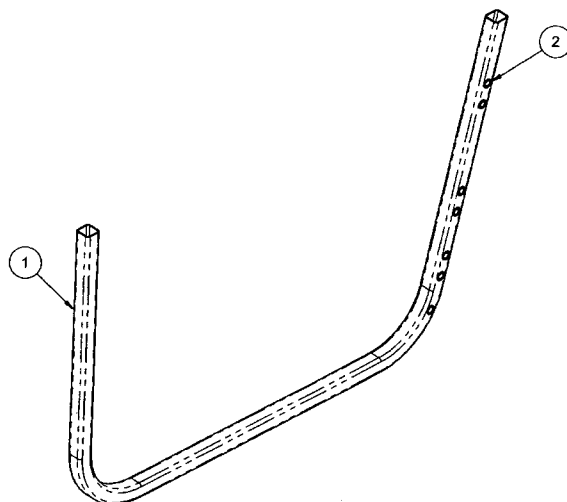
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

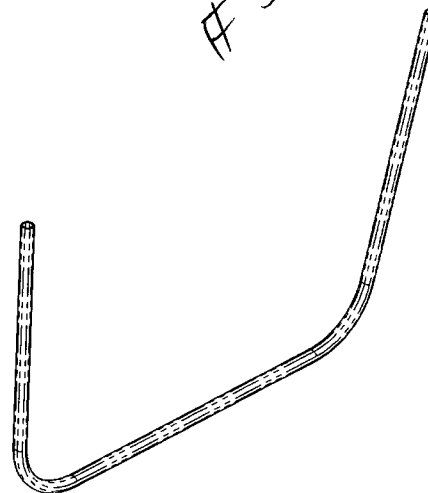
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

RELEASED
2010-03-12
JMD

A		NEW ISSUE		JPH	10.03.04
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	JPH			SHEET 1 OF 4	
CHECKED	[Signature]	DRAWING NO.		SCALE	
MFG. APPR.	[Signature]	D3916		NTS	
APPROVED	[Signature]	TITLE			
DE APPR.	[Signature]	RIB ASSY, 350 BASKET			
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD			
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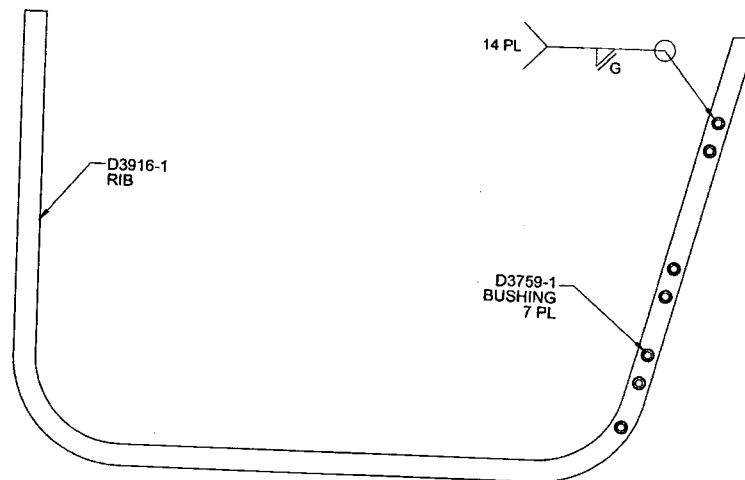
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NOTE: Date & initial all entries



D3916-041 RIB ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3916 REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE RIB ASSY, 350 BASKET SCALE NTS
DE APPR.	<i>[Signature]</i>	
DATE	10.03.04	

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2010-03-12
[Signature]

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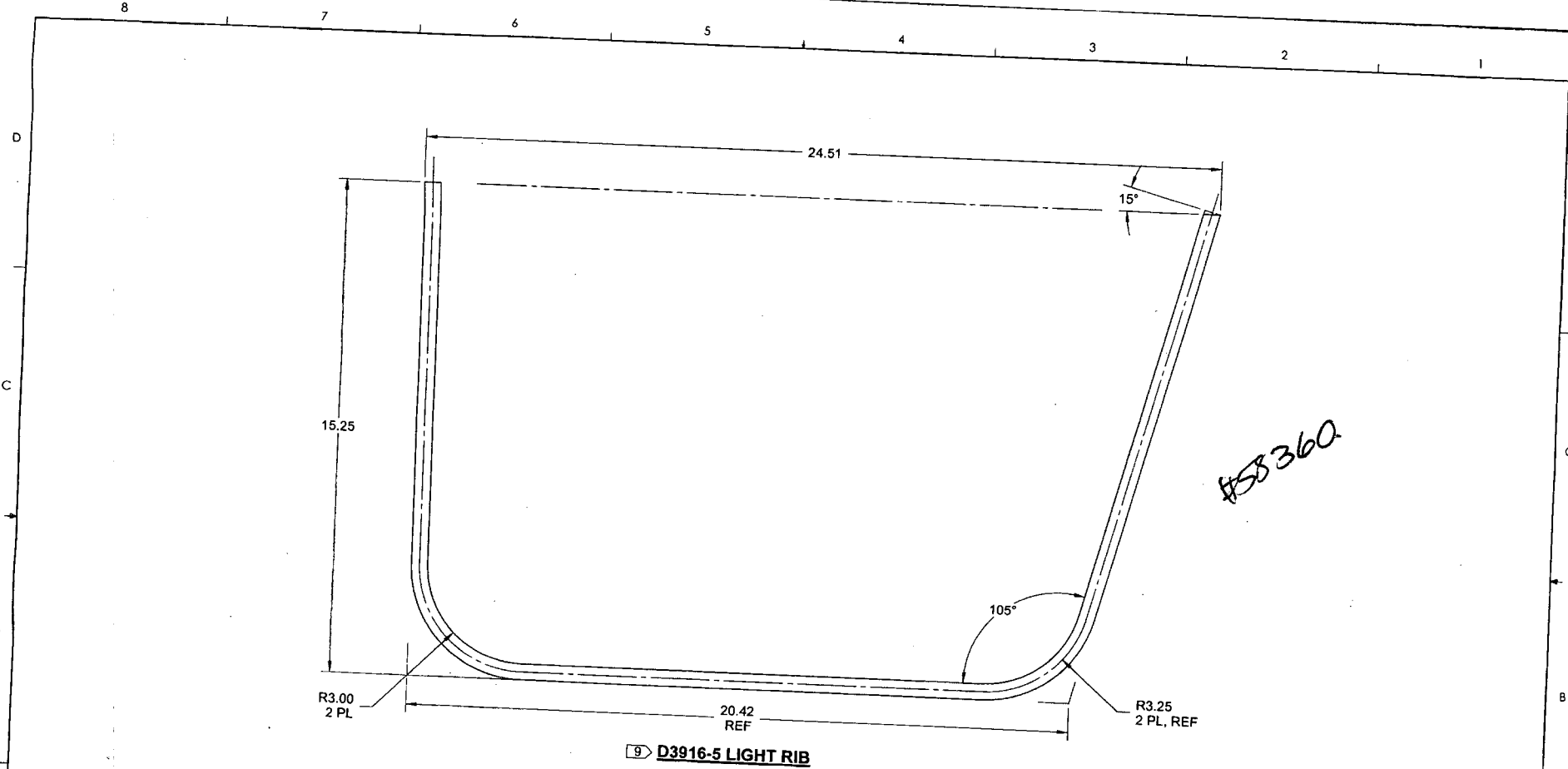
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9 D3916-5 LIGHT RIB

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.07 lbs
 - 9) TUBE FLAT LENGTH 49.5 REF

RELEASED
2010-03-12
JNP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3916	REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	RIB ASSY, 350 BASKET	SCALE
DE APPR.	<i>[Signature]</i>		NTS
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